Work Orde January-07-14	er ID 110674 3:00:18 PM			*11	იგ:	74*						Page 1
Revision ID:	D3393-1 Battery Lock Casing			Accept	*	1900	040	100)* s	Setup Star	I VI	S1* S2*
Start Date: Required Date: Reference:	1/07/14 Start Qty: 1/07/14 Req'd Qty		*10* *10*			Cust Item I Customer:	ID:					
Approvals:	Process Plan:QC:	MLJ	Date: <u>14-01-10</u>	Tooling: SPC (Y/N):			ate:		F	tun Star Sto	^I\\	R1* R2*
Sequence ID/ Work Center II	Operation Description	· 1	.,,	Set Up/ Run Hours		Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		-	•								
D3393	Rev A			•		7.4						
100 *100* Bandsaw	BAND SAW	Iemo	· ·	0.00					10	\$		DR 14-01-3
Jeaspa Bandsaw	C	ut blank: 1.:	500" x 1.500" x 3.125" lor	ng		•						Pto >
*110 *110* HAAS 1		/ERTICAL Iemo	MACHINING #1	0.00	• •				_10_			NH 14-02-4
HAAS CNC vertical		fachine D33	93-1 as per Folio FA510 a	nd Dwg D3393Identi	fy as D339	23-1						
*1.20 *1.20* QC	· .	parts off ma	chine FAI/FAIB	0.00					10		p	NH 14 -02-02

Memo

Quality Control

DQA:	Ofwit-	_ Date:	14/0	6(24								DART
QA Closed: (Date:	141	610	WORK ORDER NON	I-C(ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Orde	er: 1101			O, TO	DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Part N	10. <u>D33</u> 9	13-1	ì		Rework Scrap X Use-as-is Suspected Unapproved			Skid-tube Crosstub Machining X Small Fa moforming Finishin Large Fab Composit	b g	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Desc	iption of work order update	l l	Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	<u>X</u> iY/ox/o	110	\	R(. o	champer too deep. ns champer tool. perotor uso wron: Ver tool for perediction typ t tool wont les	1.4	DAS 16 9-89 02042 102103	Scrap and Dostroy replace with 126075 Re Labe tool's to Prent mistake: ADD Sto on Revenlentia of set ups:	 >O	MH 14103/a	m/ 14/02/02 - N/A	DAS 16 9-89 Q.>ZO42 14/02/03
					<u> </u>	FA	ULT CA	TEGORY				
Landin	ng Gear				General		_			-		_
	Cracks Crimp/K Cuffs Crushing Heat Tre Inspectic	at on Strip in	e/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruc Misali Mislab Misrea Off-set Out of	tion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d	%	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct issing Vrong Surge	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
1	Wave/T	wist in Tul	ne .	- 1	Fit/Function	1	Out of	Sequence				

T W 7		Orde	TT	440	
$\mathbf{A} \wedge \mathbf{A}$	7	Inda	~ 1	1 1 1 1 1 1 1	L' / /
V V ()		11111			I) /

110674

Page 2

January-07-14 3:00:18 PM Item ID: D3393-1 Accept Setup Start *N900040100* Revision ID: Stop **Battery Lock Casing Item Name:** *10* **Start Otv:** 10.00 **Start Date:** 1/07/14 **Cust Item ID:** Required Date: 1/07/14 Reg'd Oty: 10.00 *10* **Customer:** Reference: Run Process Plan: Tooling: Date: **Approvals:** Date: Stop SPC (Y/N): Date: _____ Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code Oty Otv Number Stamp ml 14/02/02 130 QC8- Inspect parts - second check 0.00 *120* QC 0.00 Memo **Ouality Control** 140 Chemical Conversion Coat per QSI005 4.1 0.00 10 7/5/14:23 *140* HandFinish 0.00 Memo Hand Finishing

150

150 Powdercoat

Powder Coating

Fire Red(Ref:4.3.5.10) per QSI005 4.3

Memo

FINISH TIME:

0.00

0.00

OVEN TEMPERATURE:

10 6 H-5-14. 383

DQA:			Date:										TOACT
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order update or	nly 📗	
Work Ord	or.					DISPOSITION			AGAINST	DE	PARTMENT/PROCE	SS	
WOIK OIG	٠٠.					Rework	ı		Skid-tube Crosstube	Г] Wate	er Jet	Engineering
Part i	۷n.					Scrap			Machining Small Fab	-	Prod. Eng. (\vdash	Quality
	٠٠.					Use-as-is			noforming Finishing	-	Rec/Store/Packa		Other
NCR I	۷o. ِ					Suspected Unapproved			Large Fab Composite	-		pplier	
Root	-		1		Desc	ription of work order update		initial	Action		Sign &		
Cause		Date	Step	Qty	0000	or non-conformance		ief Eng			1 1	ication	QC Inspector
Design	П		0.00	~-,									
Doc/Data	П												
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup		1	1				ļ						
Process													
Supplier													
Training				:								:	
Transport	Ш												
Unapproved											<u> </u>		
			<u>-</u>				FA	ULT CAT	TEGORY		· · · · · · · · · · · · · · · · · · ·		·-
Landi	ng (ı				General	<u> </u>	1		_	.		•
		Bending			_	Bend	<u> </u>	1 '	Program	L	Outside Dimensions		Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain		<u></u>	Over/Under tolerand		Set-up
x	-	Cracks				Broken/Damage/Defect		Hardwa			Part Incorrect	-	Temperature/Cure
14 14 2	-	Crimp/Kir	nk/Ripple	/Wave		Burrs	<u> </u>	4 '	ion Incomplete/Unqualified	_	Part Lost/Missing		Weld
	$\overline{}$	Cuffs				Contamination	<u> </u>	4	tions Incomplete/Unclear	H	Part Moved		Wrong Stock Pulled
	-	Crushing				Countersink	\vdash	4 7	gned/off center	-	Positioned Wrong		Othor
	_	Heat Trea			-	Cut Too Short	\vdash	Mislabe			Power Loss/Surge	Ш	Other
	\vdash	Inspectio		Tube	-	Drawing	\vdash	Misread					
	<u> </u>	Marks/Ch			\vdash	Drill Holes	<u> </u>	Off-set					
	<u> </u>	Turning S				Finish	\vdash	4	Calibration			,	
	1	Wave/Tw	/ist in Tuł	oe -		Fit/Function	1	Out of	Sequence				

												
Work Orde January-07-14		0674		*110	674*						Page 3	
Item ID: Revision ID:	D3393-1			Accept	*N900	<u>0401</u>	NN*	Setup	Start	*N:	S1*	
Item Name:	Battery Lock C	Casing							Stop	*N:	S2*	
Start Date:	1/07/14	Start Qty: 10.00	*10*		Cust Item I	D:						
Required Date: Reference:	: 1/07/14	Req'd Qty: 10.00	*10*		Customer:				_			
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:		Run	Start	*NI	R 1*	
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*NI	₽2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hougs	Tool ID	Tool # Pla	an Acco	ept Re Qt		Reject Number	Insp. Stamp	
160		QC3- Inspect Part Finish		0.00 27			î o					
160 QC Quality Control		Memo		0.00 Y S 1	H		<u>/()</u>					
170		Identify as per dwg & Sto	ock Location T49	<i>)</i> 70.00								
170 Packaging Packaging		Memo		0.00			70	<u> </u>		1/-5	-15	DA 20 94
100		OCCI FI II	W I O I D I						1) .	10	94
180		QC21- Final Inspection -	work Urder Release	0.00				14	115	15	14	
1 A \(\right) QC Quality Control		Мето		0.00					1/2	1,5	<u>'</u> ()	

MLJ 14-05-15

DQA:			Date:										DAR	T
			D . 4.			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	\ A /	ark Order un	data only	AEROSPA	CE
QA Closed:			Date:	-			_			VV	ork Order up	date only		
Work Orde	or.					DISPOSITION			AGAINST	ΓDE	PARTMENT	PROCESS		
	-					Rework	1		Skid-tube Crosstube	٦	,	Water Jet	Engineering	7
Part N	No.					Scrap			Machining Small Fat	-	Prod	d. Eng. Coor.	Quality	7
	-					Use-as-is			moforming Finishing		Rec/Stor	e/Packaging	Other	7
NCR I	No.					Suspected Unapproved			Large Fab Composite]	Supplier]
						::			l Ashina		I cian o I			
Root		D - 4 -	C		Desci	ription of work order update		Initial	Action		Sign &	Verification	QC Inspecto	•
Cause	\dashv	Date	Step	Qty		or non-conformance	Cn	ief Eng	Description		Date	verification	QC IIIspecto	
Design	Н													
Doc/Data	\vdash		İ											
Equip/Tooling														
Handling/Pre	\vdash													
Material	Н													
Operator	Н						1							
Offset/Setup	-													
Process	Н													
Supplier Training	Н			<u> </u>	İ	·								
Transport	H													
Unapproved	H													
опаррточеа			.l		1		FA	ULT CA	TEGORY		<u></u>	· · · · · · · · · · · · · · · · · · ·		
Landi	ng G	ear				General								
	<u> </u>	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Concei	ntric		BOM/Route		Grain	-		Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	:i	Temperature/Cur	е
		Crimp/Kii	nk/Ripple	/Wave		Burrs	Г	Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulle	ed
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong		
		Heat Trea				Cut Too Short		Mislab	eled		Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set			-			
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	ре		Fit/Function		Out of	Sequence					_

Page 1

Work Order ID:

110674

Parent Item:

D3393-1

Parent Item Name:

Battery Lock Casing

Start Date: 1/07/14

Required Date: 1/07/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A05.02.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.500		Purchased	No			100	f	69.0000	0.2708	2.850526	2	\checkmark	
6061-T6 Bar 1.50 x 1.50				Location		Loc Oty	<u>Lo</u>	c Code	() () () () () () () () () ()		1	4-01-	31
				MAT003		69			Z. 5	820			
				M12	26043	44							
				M12	26075	25							

DQA:			Date:											TOAPT
						WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE				AEROSPACE
QA Closed:			Date:								W	ork Order up	odate only	
Work Orde	er:			•		DISPOSITION	ï			AGAINST	DE	PARTMENT	/PROCESS	
	•					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1	Therr	noforming	Finishing		Rec/Sto	re/Packaging	Other
NCR N	lo.	·				Suspected Unapproved]		Large Fab	Composite]	Supplier	
Root					Desci	ription of work order update		nitial	Act	ion		Sign &		
Cause	Ì	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector
Design						,								
Doc/Data														
Equip/Tooling														
Handling/Pre					1									
Material														
Operator														
Offset/Setup												•		
Process .														
Supplier														
Training														
Transport				}			l							
Unapproved				<u> </u>			<u> </u>					<u> </u>		
							FA	ULT CA	TEGORY					
Landi		1			_	General]			_	Outside Dim	i [Pressure/Forced
		Bending			-	Bend BOM/Revite	\vdash	4	Program		H	Over/Under	<u></u>	Set-up
		Centre No	ot Concer	ntric	-	BOM/Route	\vdash	Grain Hardwa	~~		┝	Part Incorre	F	Temperature/Cure
		Cracks	ale/Dimmlo	/\4/==	\vdash	Broken/Damage/Defect		4	ion Incomplete/Ur	aualified	\vdash	Part Lost/Mi	-	Weld
		Crimp/Kir	тк/кірріе	y wave	-	Burrs		4 '	tions incomplete/U		-	Part Moved		Wrong Stock Pulled
		Crushing			-	Contamination Countersink	\vdash	-	gned/off center	Jucical	-	Positioned V	_	
		Crushing Heat Trea	at		\vdash	Cut Too Short	\vdash	Mislabe	=		\vdash	Power Loss/		Other
		Inspectio		Tube	-	Drawing	\vdash	Misrea			<u> </u>	J. 0446, 2033/		100.00
	-	Marks/Ch		IUDE		Drill Holes	\vdash	Off-set						
		Turning S				Finish		4	Calibration					
		Wave/Tw				Fit/Function		4	Sequence					

DART AEROSPACE LTD	Work Order:	110674
Description: Battery Lock Casing	Part Number:	D3393-1
Inspection Dwg: D3393 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+0.010/-0.000	-751	<u> </u>		Caliper	MH-04
0.625	+0.010/-0.000	.678	1		,	1
Ø1.250	+/-0.010	1.2485	1			
1.088	+/-0.010	1.084	/			
Ø0.734	+/-0.010	.738				
2.658	+/-0.010	2.658				
1.550	+/-0.010	1-549	✓			
0.125 x 45°	+/-0.010 x 0.5°	. 125 x450				
1.50	+/-0.030	1.490				
0.750	+/-0.010	- 750	J			
Ø1.050	+/-0.010	1.050)			
Ø1.000	+/-0.010	,ष १८	✓			
0.338	+/-0.010	, 338	1		·	
0.563	+/-0.010	.566				
0.100	+0.000/-0.010	-100	\ \			
3.00	+/-0.030	3.00				
1.500	+/-0.010	M 1. 498	✓			
0.375	+/-0.010	.377	✓			
1.25	+/-0.030	1-248	. 🗸			
0.125	+/-0.010	.115	✓ 			·
30°	0.5°	30~		-	onske Finde	- 1

	Measured by:	My	Audited by:	onl	Prototype Approval:	N/A
٠	Date:	14/07/01	Date:	14/02/02	Date:	N/A

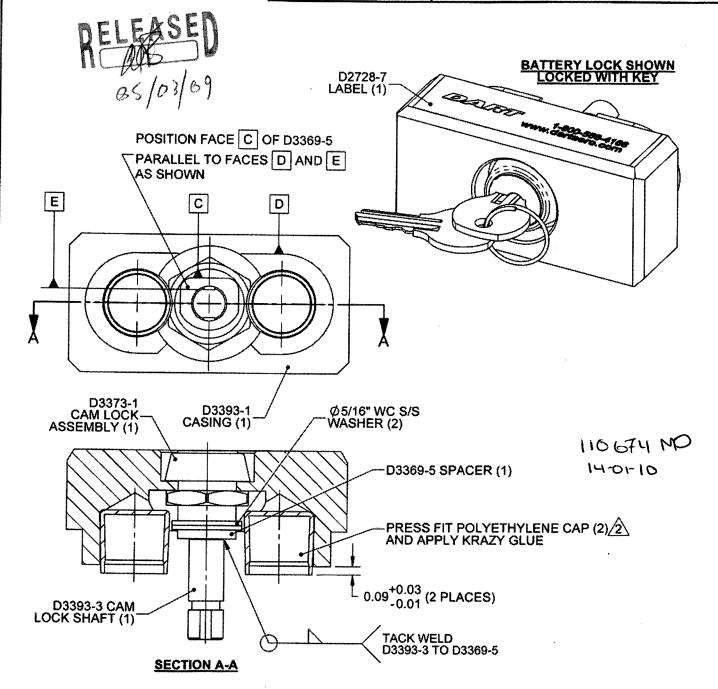
Rev	Date	Change	Revised by	Approved
Α	05.04.27	New Issue	KJ/JLM 1.A	
В	08.11.28	Tolerances revised	KJ/EC	77

DQA: Date:												DART			
						WORK ORDER NON-CONFORMANCE / UPDATE									AEROSPACE
QA Closed:			Date:			Work Order update only									
				DISPOSITION											
Work Order	^{-:} -					Power!	ı		Skid-tube	\neg		Water Jet		Engineering	
Part No	_					Rework Scrap			Machining	Crosstube Small Fab	\dashv	Pro	d. Eng. Coor.		Quality
Partino	ر. -	· · ·				Use-as-is			noforming	Finishing			e/Packaging		Other
NCR No	2					Suspected Unapproved	il	1110111	Large Fab	Composite		1100,0101	Supplier		
	-	· · · · · · · · · · · · · · · · · · ·					,								
Root					Desc	ription of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Design															
Doc/Data	_									•					
quip/Tooling	4		İ				١								
landling/Pre	4			l											
Material	4		ļ												
Operator	4	[•									
Offset/Setup	4														
rocess	4														
iupplier	\dashv	ļ													
raining	\dashv	:	ļ				Ì				l				
Transport	\dashv						1								
Jnapproved		1					FΔI	ΙΙΙΤ (Δ)	I TEGORY						
Landing	ø G	ear				General	17	OLI CA	LOOKI	 	•				·
[_	Bending				Bend	Г	 Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
-	_	Centre Not Concentric				BOM/Route	\vdash	Grain	J		-	Over/Under			Set-up
ļ-		Cracks				Broken/Damage/Defect		Hardwa	re		-	Part Incorrec			Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave		Burrs		1	ion Incomplete/U	ngualified		Part Lost/Mi			Weld
	Cuffs					Contamination		f '	ions Incomplete/	·	_	Part Moved	-		Wrong Stock Pulled
	Crushing					Countersink	-	1	ned/off center		-	Positioned Wrong			
	Heat Treat				Cut Too Short	-	Mislabeled			-	Power Loss/S	· ·		Other	
	٦	Inspection	Strip in	Tube		Drawing		Misread	d	•		1			
T		Marks/Cha	atter			Drill Holes		Off-set			•				
_^ -	$\sqrt{}$	Turning Se	quence			Finish		Out of (Calibration						
•	Δ	Wave/Twi	ct in Tub	^		Fit/Function		Out of	Sequence			-			·- ·

ssurance\approved QA/NCRWO RevH



	ESIGN	3	DRAWN BY	DART AEROSPA HAWKESBURY, ONTAR			
C	CHECKÉD APPROVED		APPROVED	D3393	REV. A		
D	ATE	05.0	02.08	BATTERY LOCK	SCALE 1:1		
	A-	0	5.02.08	NEW ISSUE			



D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

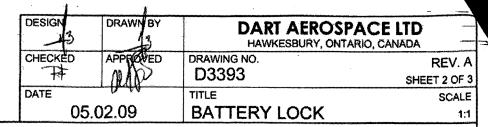
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

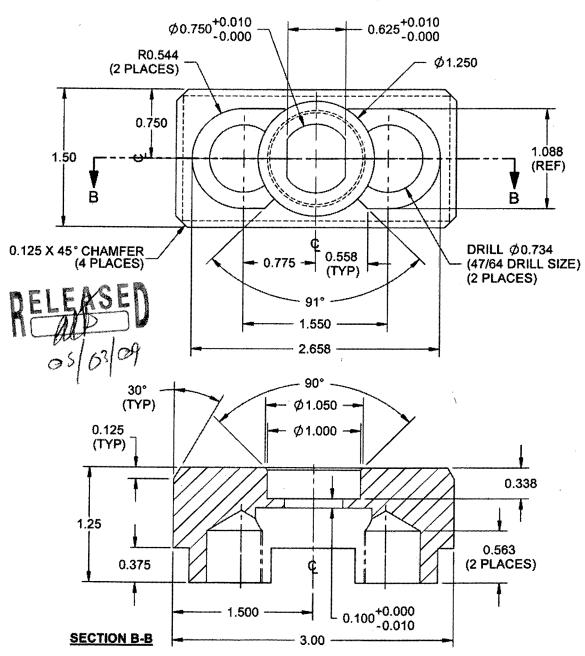
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DQA:		Date:										TART
	•				WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE			_	AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	
Work Order:					DISPOSITION							
, TOTAL OT GET				-	Rework	1		Skid-tube Crosstu	be	1	Water Jet	Engineering
Part No.				'	Scrap			Machining Small F	ab 🗌	Pro	d. Eng. Coor.	Quality
		•			· Use-as-is			noforming Finishi	~ <u> </u>	Rec/Stor	re/Packaging	Other
NCR No.					Suspected Unapproved			Large Fab Composi	te[}	Supplier	
Root				Desci	ription of work order update		nitial	Action		Sign &	.	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design	_							. `.				
Doc/Data	-											·
Equip/Tooling Handling/Pre	-											
Material	1											
Operator	4 1										·	
Offset/Setup	1											
Process	1				·							
Supplier												
Training												
Transport												
Unapproved											.1.	
						FAI	ULT CAT	regory				
Landing	_			_	General		1			7	г	_
	Bendin	_		_	Bend	<u> </u>	1	rogram		Outside Dim	F	Pressure/Forced
<u> </u>	Centre Not Concentric			 	BOM/Route	<u> </u>	Grain			Over/Under		Set-up
<u> </u>	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		-	Part Incorred	-	Temperature/Cure
	Crimp/Kink/Ripple/Wave			-	Burrs	\vdash	1 .	ion Incomplete/Unqualified	-	Part Lost/Mi	- F	Weld
-	Cuffs				Contamination		4 .	ions Incomplete/Unclear	-	Part Moved	_	Wrong Stock Pulled
· .	Crushing				Countersink	\vdash	1 -	ned/off center	-	Positioned V		Othor
<u> </u>	Heat Treat Inspection Strip in Tube				Cut Too Short	\vdash	Mislabe		L	Power Loss/	ourge [Other
	⊣	ion Strip in Chatter	rube	\vdash	Drawing Drill Holes	\vdash	Misread Off-set			· · · · · · · · · · · · · · · · · · ·		
\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	-4	Sequence		\vdash	Finish	\vdash	-	Calibration				<u> </u>
· · · · · · · · · · · · · · · · · · ·		s sequence Twist in Tul		-	Fit/Function	\vdash	-	Sequence		-		

ssurance\approved QA/NCRWO RevH







D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
 (REF. DART SPEC. M6061T6B)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

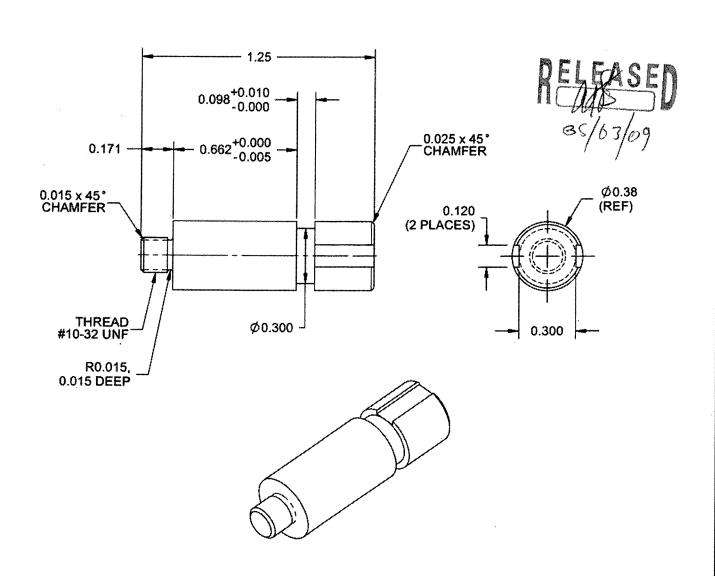
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

DQA: Date:					_								TOAPT	
						WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:	ate: Work Order update only										
						DISPOSITION								
Work Ord	er: ₋					5 .			Click and a Consequence			Water Jet	7 Facinossins	
0	\.					Rework			Skid-tube Crosstube Machining Small Fab	-	Dro	d. Eng. Coor.	Engineering Quality	
Part i	۷O					Scrap Use-as-is			Machining Small Fab noforming Finishing	-		re/Packaging	Other	
NCR I	No.					Suspected Unapproved		men	Large Fab Composite	-	Nec/3to	Supplier		
NCKI	١٠٠.					Suspected Onapproved	l		composite			Supplie!		
Root					Desci	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	1	Date	Verification	QC Inspector	
Design											•			
Doc/Data														
Equip/Tooling										ŀ			į	
Handling/Pre	Ш													
Material	Ш									ı	•			
Operator	Щ													
Offset/Setup														
Process	Ш													
Supplier	Н	-								ĺ				
Training	Н									i				
Transport	Н													
Unapproved	Ш		l	İ	L		EAL	HT CAT	I regory					
Landi	na G					General	FA	JLI CA	IEGONI					
Lanui		Bending				Bend		 Folio/F	Program	\Box	Dutside Dim	ensions [Pressure/Forced	
	H		nt Concer	ntric	 	BOM/Route		Grain	TOBIGITI	$\overline{}$	Over/Under	—	Set-up	
	Н	Centre Not Concentric Cracks				Broken/Damage/Defect	\vdash	Hardwa	ire .	\vdash	Part Incorre		Temperature/Cure	
	Crimp/Kink/Ripple/Wave			/Wave		Burrs	 	ł	ion Incomplete/Unqualified	$\boldsymbol{\vdash}$	Part Lost/M	· •	Weld	
	Cuffs			Contamination	-	1	tions Incomplete/Unclear	_	Part Moved	_	Wrong Stock Pulled			
	Crushing			Countersink	-	1	gned/off center		Positioned V					
	Heat Treat				Cut Too Short	-	Mislabe		-	Power Loss/	· ·	Other		
20-	П	Inspection	n Strip in	Tube		Drawing	\vdash	Misread		Ш	·	· _		
	$\vdash \vdash$	Marks/Ch	•			Drill Holes	Г	Off-set		-	·	· · · · · · · · · · · · · · · · · · ·		
. \	\Box					Finish	Г	Out of	Calibration	-				
	Turning Sequence Wave/Twist in Tube					Fit/Function		Out of Sequence						

ssurance\approved QA/NCRWO RevH



		<u> </u>	•	·
	DESIGN	DRAWN BY	DART AEROSI	
L		(Hammell)	HAWKESBURY, ONT	ARIO, CANADA
Ī	CHECKED	APPROVED	DRAWING NO.	REV. A
L	- *	1 010	D3393	SHEET 3 OF 3
	DATE	6AC	TITLE	SCALE
	05.	02.09	BATTERY LOCK	2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

MARKET

petitioner.

QA:	Date:						TAART						
						WORK ORDER NON-	AEROSPACE						
A Closed:			Date:				_			VV	ork Order u	date only	<u> </u>
Work Order:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
voin oraci	_				_	Rework			Skid-tube	Crosstube]	Water Jet	Engineering
Part No	о.					Scrap		ī	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is			noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o			•	_	Suspected Unapproved			Large Fab	Composite	J	Supplier	
Root	T				Desci	ription of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
sign													
oc/Data													
uip/Tooling	╛		İ								ļ		
indling/Pre	╝											· ·	
aterial													
perator											,		
fset/Setup													
ocess													
pplier	╝						l						
aining													
ansport							1						
napproved													
						·	FAI	JLT CAT	TEGORY				
Landin	g G	ear				General				_	-	_	-
L	_	Bending			L	Bend		Folio/P	rogram	<u> </u>	Outside Dim	ensions	Pressure/Forced
L	Centre Not Concentric			BOM/Route		Grain			Over/Under tolerance		Set-up		
L	Cracks					Broken/Damage/Defect		Hardwa	re	L	Part Incorrect		Temperature/Cure
	Crimp/Kink/Ripple/Wave			/Wave	Burrs		Inspecti	ion Incomplete/U	Inqualified	Part Lost/Missing		Weld	
	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled	
	Crushing					Countersink		Misalig	ned/off center		Positioned \	Wrong	_
. [Heat Treat			Cut Too Short		Mislabe	eled				Other		
Γ	Inspection Strip in Tube					Drawing		Misread					
	Marks/Chatter					Drill Holes		Off-set					
_ \ \ \ \	_	Turning Se				Finish		Out of Calibration					ui.
	$\overline{}$	Wave/Twi		e		Fit/Function	\vdash	1	Sequence				
A.	Ţ			/NCRWC		rigitaliedori	1	lout or t	requeries			 	